



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D412-742-043
Job Sheet 175926



Part No: D412-742-043

Job Qty: 1 ea

Part Name: Repl. Skidtube Fits LH or RH, High Gear, DART (Apical) Tri-Bag Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/12/18

Job Tracking No:

Due Date: 5/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3391-043 REV J SHEETS 1,2 IPP Rev A 05.10.13 New Issue KJ/JLM IPP Rev 06.02.13 ECN 773 dwg
@ rev.D EC IPP Rev:C 07-05-28 As per Rev F JLM IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM IPP
Rev:E 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:F 11.11.01 as per DSI9517 REV.B DD verified by:EC
IPP REV:G 16.05.02 AS PER DWG REV.J DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		5/19/18	0.00	0.00	Start Up Container		18-5-30
110	HandFinish	1 pcs		5/21/18	0.00	3.50	HandFinish4		18-5-30
120	QC	1 pcs		5/21/18	0.00	0.00	QC5		38
125	DC	1 pcs		5/21/18	0.00	0.00	DC		9-88
130	Packaging	1 pcs		5/21/18	0.00	0.00	Packaging3-2		DAS
140	QC21-FG	1 Ea		5/21/18	0.00	0.00	QC21		21 MAY 31 2018

Part Op 110 - 1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with
Descriptions: saddle holes for proper alignment. using 7/16" "T" Pins. A/R Sikaflex-241/-291 M138787 Expiry date:
1812 2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped
with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no
sikaflex. A/R Sikaflex-241/-291 M138787 Expiry date: 1812 3-Remove "T" pins once sikaflex is dry.
4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/R LPS Procyon
M133610 VERIFY FWD AND AFT SADDLE FIT DURING ASSEMBLY BY: _____ DATE: _____
125 - If D412-742-043 is a W/O on it's own, Photocopy bluefile and create labels per PPP D412-742-043 CHG007
130 - Identify and pack for shipping as per PPP D412-742-043 Location: _____ PPP Rev: _____

003552

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C4A	Bolt	24 Ea (24 ea)	90-Start up Operation	5041114
AN3C6A	Bolt	4 Ea (4 ea)	90-Start up Operation	5019397
AN5C7A	Bolt	10 Ea (10 ea)	90-Start up Operation	5019411
D3391-021	Fwd Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5064678
D3391-023	Mid Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5074060
D3391-025	Aft Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5063137
D4095-041	Wearplate Fwd	1 Ea (1 ea)	90-Start up Operation	5006663
D4095-043	Wearplate Aft	1 Ea (1 ea)	90-Start up Operation	5029727
D4095-045	Wearplate Center	1 Ea (1 ea)	90-Start up Operation	5041025
NAS1149C0332R	Washer	28 Ea (28 ea)	90-Start up Operation	5056493
NAS1149C0532R	Washer	10 Ea (10 ea)	90-Start up Operation	504735

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By																																																							
								Lead hand / Supervisor Approval Verification																																																							
										QC / QA Coordinator Approval																																																					
Root Cause		FAULT CATEGORY																																																													
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
																								OTHER :																																							

90-Start up Operation

AN3C4A	24	2,377	0
AN3C6A	4	294	0
AN5C7A	10	152	0
D3391-021	1	2	0
D3391-023	1	3	0
D3391-025	1	1	0
D4095-041	1	11	0
D4095-043	1	14	0
D4095-045	1	10	0
NAS1149C0332R	28	6,679	0
NAS1149C0532R	10	397	0

Part Specifications

Specifications could not be found.

Plex 4/12/18 11:42 AM Dart.lajeunesse.marie



Container No: S076565



Part: D412-742-043

Job No: 175926

Serial No/Batch: S076565

Revision: A/J

Inspector:

Exp Date: 05/30/2018

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/30/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

